



Dart Aerospace Ltd.
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D3914-041
Job Sheet 201276



Part No: D3914-041

Job Qty: 1 pcs

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/30/19

Job Tracking No:

Due Date: 11/11/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF.JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	11/11/19	11/11/19	0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		MAL
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	11/11/19	11/11/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		LZ
							QC 9 - 9		
120	QC 5	1 pcs	11/11/19	11/11/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



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Container No: S228940



Part: D3914-041

Job No: 201276

Serial No/Batch: S228940

Revision: A/D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/01/19

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						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	EL
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
130	Powdercoat - 4 Black Sand - B4B	1 pcs	11/11/19	0.00	0.40	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	EL 19-11-11.
						Powdercoat - 4 - B4B	
START: 2:35 O.T. 3:00 FINISH: 3:05 M156440							
135	QC 3	1 pcs	11/11/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	HL 19-11-12
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
140	Handfinish - 3-1- WingWalk- B4B	1 pcs	11/11/19	0.00	0.80	Handfinish - 3 - 1 - B4B	HL 19-11-12
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
150	QC 3	1 pcs	11/11/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	BEB 19-11-12.

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DAS
15
-89DAS
59
9-89

						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
						QC 3 - 81	
160 Packaging 3-1 - Stock - B4B	1 pcs	11/11/19	0.00	0.00	Packaging 3 - 1 - B4B	M 19-11-12	
					Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		
					Packaging 3 - 5 - B4B		
					Packaging 3 - 6 - B4B		
					Packaging 3 - 7 - B4B		
					Packaging 3 - 8 - B4B		
					Packaging 3 - 9 - B4B		
					Packaging 3 - 10 - B4B		
					Packaging 3 - 11 - B4B		
					Packaging 3 - 12 - B4B		
					Packaging 3 - 13 - B4B		
					Packaging 3 - 14 - B4B		
					Packaging 3 - 15 - B4B		
					Packaging 3 - 16 - B4B		
					Packaging 3 - 17 - B4B		
					Packaging 3 - 18 - B4B		
					Packaging 3 - 19 - B4B		
					Packaging 3 - 20 - B4B		
					Packaging 3 - 21 - B4B		
					Packaging 3 - 22 - B4B		
					Packaging 3 - 23 - B4B		
					Packaging 3 - 24 - B4B		
					Packaging 3 - 25 - B4B		
					Packaging 3 - 26 - B4B		
					Packaging 3 - 27 - B4B		
					Packaging 3 - 28 - B4B		
					Packaging 3 - 29 - B4B		
					Packaging 3 - 30 - B4B		
					Packaging 3 - 31 - B4B		
					Packaging 3 - 32 - B4B		
					Packaging 3 - 33 -		
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				B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	1	11/11/19	0.00 0.00	QC 21 - SA - 21	DAS
	pcs			QC 21 - SA - 70	NOV 12 2019 70
				QC 21 - SA - 53	9-89

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: M139016 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld Descriptions: hinge (3) and Mounting brackets as per dwg D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh***

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 *** mask sides of hinge prior to powdercoat***

135 - QC3- Inspect Part Finish

140 - Wing Walk as per dwg QSI005 4.4 Batch _____ 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location: _____

170 - QC21- Final Inspection - Work Order Release

M4# 012727

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5211240
D3914-1 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5222855
D3914-7 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5221681
D4016-3 ✓	Hinge Half, Lid	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	5221960
D4018-5 ✓	Rib	9 pcs (9 ea) ✓	100-Large Fab - Basket - 1	5223010
D4020-5 ✓	Mesh (350 Basket Long, Lid)	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5219012
D4021-3 ✓	Data Plate	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5172801
D4035-043 ✓	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5225517

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	131	0
	D3914-1	2	6	0
	D3914-7	2	16	0
	D4016-3	3	36	0
	D4018-5	9	53	0
	D4020-5	1	2	0
	D4021-3	1	18	0
	D4035-043	2	14	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



DISPOSITION		DEPARTMENT/PROCESS					
Job: _____	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐		
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐		
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐	Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QSI042) _____			
Description Work Order Deviation		Disposition					
Root Cause		FAULT CATEGORY					
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐			
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐			
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐			
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐			
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐				
Human Factors ☐	Other/Details: _____						